comparison of the left and right portions of Figure 6. Support for the limitation of claim 52 relating to "increase said height of said can end" during seaming is clear from a comparison of the right hand portion of Figure 7 with the left hand portion of Figure 7 and both sides of Figure 6. Support for the limitation of claim 61 relating to "said first seaming operation driven by said rotating chuck . . . without driving contact between said chuck and a base of said can end bead interior surface" is found at page 6, lines 21-27 and Figures 5 through 7.

Attached is a marked-up version of the changes made to the claims by the current amendment, captioned "Version With Markings To Show Changes Made."

CONCLUSION

Applicants request favorable examination of the new claims. If the examiner determines that a telephone conference would further prosecution of the pending claims, he is invited to telephone the undersigned at his convenience.

Respectfully submitted,

Harold H. Fullmer
Registration No. 42,560

Date: April 24, 2003
WOODCOCK WASHBURN LLP
One Liberty Place - 46th Floor
Philadelphia, PA 19103
(215) 568-3100

VERSION WITH MARKINGS TO SHOW CHANGES MADE

In the claims:

Claim 34 has been amended and claims 51-67 have been added as follows:

34. (Amended) A method of forming a double seam between a can body and a can end, said method comprising the steps of:

a) providing a can end having a circumferentially extending inclined wall and a peripheral curl extending circumferentially and radially outward from said inclined wall, said peripheral curl comprising a seaming panel and a radiused portion extending from the seaming panel to said inclined wall, said wall inclined between about 20° [30°] and about 60° with respect to an axial centerline of said can end;

b) placing said curl of said can end into contact with a circumferentially extending flange of a can body;

c) providing a rotatable chuck having first and second circumferentially extending walls, said first wall being substantially cylindrical;

d) bringing said chuck into engagement with said can end;

e) performing a seaming operation by placing one or more seaming rolls into contact with said curl of said can end so as to deform said curl and said can body flange into a seam, a first portion of said inclined can end wall being pressed against said chuck first wall, whereby said first portion of said inclined can end wall is bent upward through an angle of at least about 16° so as to reform said can end wall into distinct first and second portions, said second wall portion remaining inclined between about 20° and about 60° with respect to said axial centerline.

52. (New) A method of seaming a can end to a can body, comprising the steps of:

a) providing a can end having (i) a circumferentially extending peripheral curl, said peripheral curl forming a lip at one end thereof, (ii) a circumferentially extending wall extending downwardly and radially inwardly from an opposite end of said peripheral curl, at least an upper portion of said wall inclined with respect to an axial centerline of said can end, and (iii) a circumferentially extending annular bead extending downwardly

and radially inwardly from said wall, the distance from the lowermost point on said bead to the uppermost point on said curl defining a height of said can end;

b) placing said peripheral curl of said can end into contact with a circumferentially extending flange of a can body;

c) bringing a rotatable chuck into engagement with said can end;

d) bringing a seaming roll having a lower forming surface into rolling engagement with said curl, said seaming roll being positioned so that said lower forming surface is disposed above said lip of said curl upon initial engagement with said curl so that said seaming roll (i) displaces said curl upwardly as said curl is displaced inwardly and (ii) permanently bends said upper portion of said can end wall towards the axial direction so as to permanently increase said height of said can end.

53. (New) The method of claim 52, wherein at least said upper portion of said wall is inclined between about 20° and about 60° with respect to said axial centerline prior to bending of said upper wall portion of said can end.

54. (New) The method of claim 53, wherein at least said upper portion of said wall is inclined between about 30° and about 50° with respect to said axial centerline prior to bending of said upper wall portion of said can end.

55. (New) The method of claim 54, wherein at least said upper portion of said wall is inclined between about 40° and about 45° with respect to said axial centerline prior to bending of said upper wall portion of said can end.

56. (New) The method according to claim 53, wherein said bending of said upper portion of said can end wall forms a crease between said upper portion of said can end wall and a lower portion of said can end wall.

57. (New) The method of claim 52, wherein the rotatable chuck has first and second circumferentially extending walls, the first wall being substantially cylindrical, and wherein said bending of said upper portion of said can end wall causes said upper portion of said can end wall to be pressed against said chuck first wall, whereby said upper portion of said can end wall becomes substantially cylindrical.

58. (New) The method according to claim 57, wherein at least said upper portion of said can end wall is inclined between about 20° and about 60° with respect to said axial centerline prior to bending of said upper wall portion of said can end.

59. (New) The method according to claim 58, wherein at least said upper portion of said can end wall is inclined between about 30° and about 50° with respect to said axial centerline prior to bending of said upper wall portion of said can end.

60. (New) The method according to claim 59, wherein at least said upper portion of said can end wall is inclined between about 40° and about 45° with respect to said axial centerline prior to bending of said upper wall portion of said can end.

61. (New): A method of seaming a can end to a can body, comprising the steps of:

a) providing a can end having (i) a circumferentially extending peripheral curl, (ii) a circumferentially extending wall extending downwardly and radially inwardly from an opposite end of said peripheral curl, and (iii) a circumferentially extending annular bead extending downwardly and radially inwardly from said wall, said bead having inner and outer wall and a substantially convex base so as to form an interior surface thereof having a bottom;

b) placing said curl of said can end into contact with a circumferentially extending flange of a can body;

c) bringing a rotatable chuck into engagement with said can end;

d) performing at least a first seaming operation, said first seaming operation comprising placing a seaming roll into contact with said can end curl while rotating said can end so as to partially deform said curl and said can body flange into a partial seam, said rotation of said can end during said first seaming operation driven by said rotating chuck through driving contact between said chuck and said wall of said can end without driving contact between said chuck and said base of said can end bead interior surface.

62. (New) The method of claim 61, wherein an upper portion of said can end wall is inclined at an angle to an axial centerline of said can end prior to said seaming operation, and further comprising a second seaming operation that bends said wall upper portion into an approximately cylindrical shape.

63. (New) The method according to claim 62, wherein said upper portion of said can end wall is inclined between about 20° and about 60° with respect to said axial centerline of said can end prior to said first seaming operation.

64. (New) The method according to claim 63, wherein said upper portion of said can end wall is inclined between about 30° and about 50° with respect to said axial centerline of said can end prior to said first seaming operation.

65. (New) The method according to claim 64, wherein said upper portion of said can end wall is inclined between about 40° and about 45° with respect to said axial centerline of said can end prior to said first seaming operation.

66. (New) The method according to claim 63, wherein said upper portion of said wall is bent towards the axial direction so as to permanently increase the height of said can end during said first and second seaming operations.

67. (New) The method according to claim 63, wherein said rotation of said can end during said first seaming operation is driven by said rotating chuck through driving contact between said chuck and said wall of said can end without driving contact between said chuck and any portion of said can end bead interior surface